

DART SERVICE INSTRUCTION
TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS
ICA-D412-694 REV.1 OR LATER APPROVED REVISION
REF. TCCA STC: SH05-10
REF. FAA STC: SR02086NY
REF EASA STC: EASA.IM.R.S.01085

1.0 PURPOSE:

The purpose of this Dart Service Instruction (DSI) is to provide a procedure for repairing the damage shown in Figures 1 and 2 for the LH Spacedoor installed on Bell 412 EP S/N 36455.

2.0 PROCEDURE:

1. Drill out/remove the 3 x 80-005-2-8 inserts in the damaged area of the door (see Figure 1). If the repair will overlap the forward two inserts, it is acceptable to remove those two inserts as well.
2. Sand/remove the damaged/cracked laminate in the damaged area of the door (see Figure 2). Note that there is an aluminum doubler bonded to the foam core below the laminate in the damaged area of the door. If the area around the inserts is delaminated from the aluminum doubler, inject Hysol 9309NA adhesive to fill the pockets prior to layup.
3. Fill insert holes with Hysol EA934NA adhesive.
4. Once the adhesive has cured, layup a minimum of 3 layers of 9 oz 7781 Cloth using Hysol 9309NA Resin over the damaged area with a 1" overlap.
5. Once the resin has cured, locate the P/N D3183-043/-044 bracket and the D3115-1 bracket (If Required) on the door and mark the center locations of the 80-005-2-8 inserts.
6. Reinstall the 80-005-2-8 inserts at the marked locations in accordance with Section 52.10 of ICA-D412-694.
7. Touch up door finish in accordance with Table 5-2 of ICA-D412-694.
8. Reinstall the D3183-043/-044 bracket on the door in accordance with Section 52.9 of ICA-D412-694.
9. Reinstall the repaired door on the aircraft in accordance with Section 52.2 of ICA-D412-694.
10. Perform the Operational Check and Adjustment as required per Section 52.3 of ICA-D412-694.
11. Update Aircraft Logbook to indicate that DSI 9882 has been performed.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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FIGURE 1
(AFFECTED AREA)

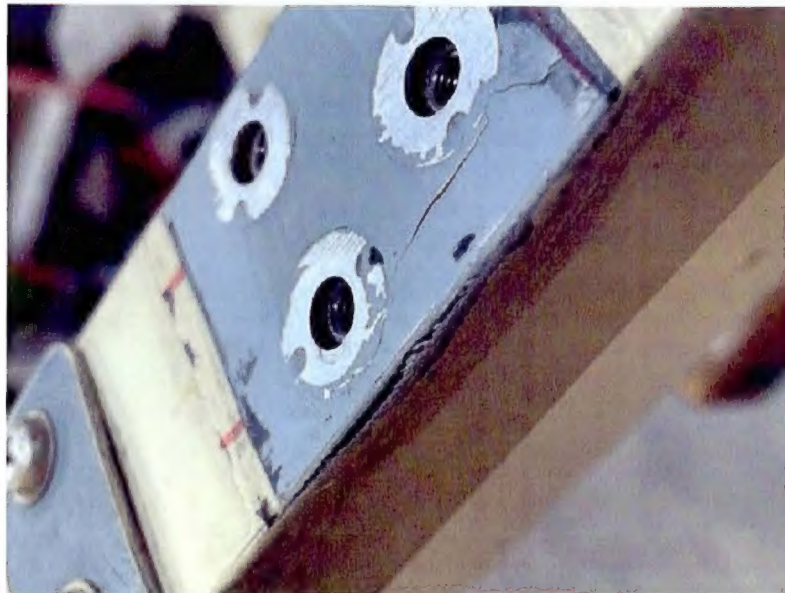


FIGURE 2
(DAMAGE)

3.0 WEIGHT AND BALANCE:

There is negligible weight change associated with this repair.

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